

Work Order ID 48670E



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July 1, 2009 9:08:11 AM

Item ID: D3140-57

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler Kit

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

Pick Kit

0.00

16/14 SQ

~~CZ 09/09/15~~ X①



Packaging

Memo

0.00

Packaging

110

QC4- 100% Inspect kits for completeness

0.00

Ship to delcostek for P10: 9004

CZ 09/09/15 X①



QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: _____

0.00

N/A

CZ 09/09/15 X



Packaging

Memo

0.00

Packaging

Work Order ID 48670E



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July 1, 2009 9:08:11 AM

Item ID: D3140-57

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Setup Start



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Item Name: Doubler Kit

Start Date: 7/15/09 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

U 9-9-16

Picklist Print

July 1, 2009 9:08:10 AM

Page 1

4

Work Order ID: 48670E

Parent Item: D3140-57RevF

Parent Item Name: Doubler Kit



Comments:

Start Date: 7/15/09



Required Date: 8/03/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3140-09RevF		Manufactured	No			100	Each	1.0000	1.0000			
										34793		SV
Doubler Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
34793	1	

D3140-101RevF		Manufactured	No			100	Each	1.0000	2.0000			
										35157		SV
Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
35157	1	

D3140-241RevF		Manufactured	No			100	Each	7.0000	1.0000			
										B 36731		SV
Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
36731	7	

9/7/11

↓ ① 9/18/14
80296 ①

Picklist Print

July 1, 2009 9:08:10 AM

Work Order ID: 48670E

Parent Item: D3140-57RevF

Parent Item Name: Doubler Kit







Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3140-301RevF  Doubler		Manufactured	No	X		100	Each	2.0000	2.0000			
				<u>Warehouse</u>	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
				Main Warehouse								
				ST			2					
				34381			1					
				36762			1					
D3140-87RevF  Doubler		Manufactured	No			100	Each	5.0000	1.0000			
				<u>Warehouse</u>	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
				Main Warehouse								
				ST			5					
				35155			5					
D3140-91RevF  Doubler		Manufactured	No			100	Each	0.0000	1.0000			

①
B36762 54
B51771x, c49109/15

B35/55 50

B36732 1x 10/9/82

9/1/11

Picklist Print

July 1, 2009 9:08:10 AM

Work Order ID: 48670E

Parent Item: D3140-57RevF

Parent Item Name: Doubler Kit

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3140-95RevF		Manufactured	No			100	Each	9.0000	3.0000			
												
Doubler												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

9

34375

9

D3140-97RevF		Manufactured	No			100	Each	4.0000	1.0000			
												
Doubler												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

37773

4

D3140-99RevF		Manufactured	No			100	Each	2.0000	1.0000			
												
Doubler												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

36761

2

9/7/11

Picklist Print

July 1, 2009 9:08:10 AM

Work Order ID: 48670E

Parent Item: D3140-57RevF

Parent Item Name: Doubler Kit



Comments:

Start Date: 7/15/09

Required Date: 8/03/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3140-103RevF		Manufactured	No			100	Each	6.0000	1.0000			
										34377		50
Doubler												

9/7/11

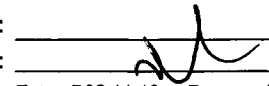
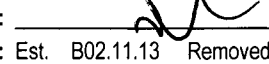
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
34377	6	

D3140-105RevF		Manufactured	No			100	Each	2.0000	1.0000			
										34379		50
Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
34379	2	

Date: Monday, 22/06/2009 9:11:35 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER KIT
Job Number	: 48670E		
Estimate Number	: 11452		
P.O. Number	:	Part Number	: D314057
This Issue	: 22/06/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3140 REV F
First Issue	: / /	Project Number	: N/A
Previous Run	: 39169E	Drawing Revision	: F
	Type : SMALL /MED FAB	Material	:
Written By	: 	Due Date	: 10/09/2009
Checked & Approved By	: 	Qty:	1
Comment	: Est. B02.11.13 Removed D3140-65/-81/-83; Added D3140-301 K J Est. Rev C New dwg rev. ecn781 06.04.18 EC Est Rev:D As per ECN #829 06-11-20 JLM		
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	✓	D314009	✓	Doubler Assembly
-----	---	---------	---	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) ✓ OK.
 Doubler Assembly

Pick:

Qty Part Number Description Batch

1 D3140-09 Doubler Assy

2.0	✓	D3140101	✓	Doubler
-----	---	----------	---	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) ✓ OK.
 Doubler

Pick:

Qty Part Number Description Batch

2 D3140-101 Doubler

3.0	✓	D3140241	✓	Doubler
-----	---	----------	---	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) ✓ OK.
 Doubler

Pick:

Qty Part Number Description Batch

1 D3140-241 Doubler

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 9:11:35 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 48670E

Part Number: D314057

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0



D3140301

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) *OK*

Doubler

Pick

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3140-301	Doubler	
---	-----------	---------	--

5.0



D314087

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) *OK*

Doubler

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3140-87	Doubler	
---	----------	---------	--

6.0



D314091

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) *OK*

Doubler

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3140-91	Doubler	
---	----------	---------	--

7.0



D314095

Doubler



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) *OK*

Doubler

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

3	D3140-95	Doubler	
---	----------	---------	--

8.0



D314097

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) *OK*

Doubler

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3140-97	Doubler	
---	----------	---------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 48670E

Part Number: D314057

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

✓ D314099

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) ✓

Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-99	Doubler	

OK.

10.0

✓ D3140103 ✓

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3140-103	Doubler	

✓ OK

11.0

✓ D3140105 ✓

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3140-105	Doubler	

OK

12.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

13.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.		DATE 09/08/21					
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Delastek 2699 ⁵ Avenue Lacaille							
ADRESSE - ADDRESS		ADRESSE - ADDRESS Grand-Mere QC G9T-5K7							
DATE D'EXPÉDITION - SHIPPING DATE		VIA		CONDITIONS - TERMS		N° D'ENR. DE TAXE - TAX REG. NO.		VENDEUR - SALESPERSON	
	2	D3140-241	B 36731						
	1	D3140-09	B 34793						
	2	D3140-87	B 35155						
	1	D3140-301	B 36762						
	2	D3140-303	B 35158						
	2	D3140-098	B 34376 x1	(B 37773 x1)	(D 3140-097)				
	1	D3140-092	B 34374						
	4	D3140-101	B 35157 x2	B 50292 x6					
	1	D3140-106	B 34380						
	1	D3140-105	B 34379						
	1	D3140-104	B 34378						
	1	D3140-103	B 34377						
	2	D3140-99	B 36767						
<p>Do Doublers to assemble the space door as per drawing.</p> <p>thanks.</p> <p>Chantal</p> <p>the rest of doublers missing will be ship at a later date.</p>									
TPS/GST									
TVP/PST									
513970		SIGNATURE		N° LIC. - LIC. NO.		TOTAL			

[illegible]